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RBT18520-9A
Job Sheet 186721



Part No: RBT18520-9A

Job Qty: 5 ea

Part Name: Extension Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520-9A REV:11 IPP REV A 18.02.06 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	5 pcs	12/7/18	12/7/18	0.08	0.31	Small Fab-9		<i>SB</i> <i>Michael</i>
110	QC	5 pcs	12/7/18	12/7/18	0.00	0.00	QC5		<i>SB</i> <i>MLC</i>
130	Packaging	5 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		
140	QC21-SA	5 Ea	12/7/18	12/7/18	0.00	0.00	QC21		

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

DAS
21 DEC 10 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91375A673	Socket Head Set Screw 7/16-14 X 1.5	5 Ea (1 ea)	100-Small Fab	<i>5131320</i>
RBT18520-9	Extension	5 Ea (1 ea)	100-Small Fab	<i>5106433</i>
<i>LOCTITE 263 (138904)</i>				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab	91375A673	5	8	0
	RBT18520-9	5	12	0

Part Specifications

Specifications could not be found.



Container No: S136174



Part: RBT18520-9A

Job No: 186721

Serial No/Batch: S136174

Revision: 11

Inspector:

Exp Date:

Instructions:

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Plex 11/20/18 1:32 PM Dart.lajeunesse.marie

Date: 12/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

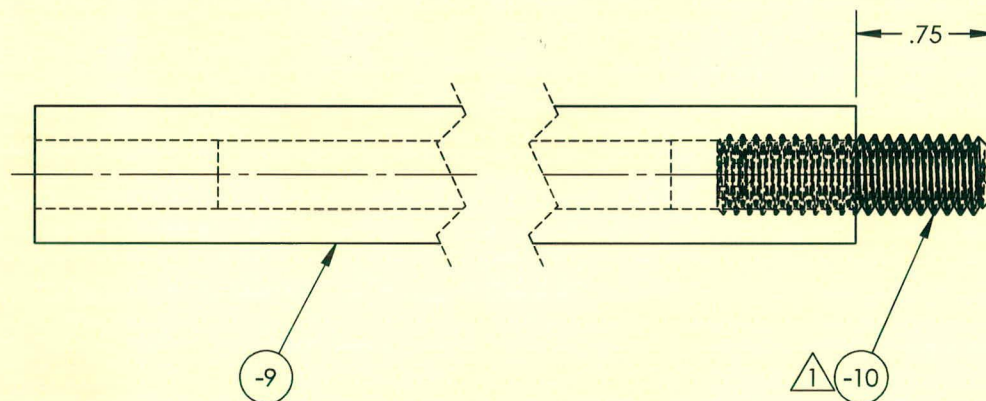
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		CH'D P/N -10 SETSCREW DEPTH TO .75 PER G.E.	9/28/2009	RJC	-
10	16-0096	-9A ADDED TO BOM.	8/4/2016	DPD	JAG
11	17-0069	-9A CH'D LOCTITE NUMBER WAS 609 IS 262.	3/22/2017	DPD	JAG



SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186721405

NOTE:

1 INSTALL -10 SOCKET HEAD SET SCREW USING
262 LOCTITE OR EQUIVALENT, ALLEN HEAD IN.

262 OR
263
miller
DEC 6/18

-9A

EXTENSION ASSEMBLY

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-9A	REV 11
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 1:1	DATE 8/17/2000
	SHEET 10 OF 17

